

**Work Order ID 62993**

Friday, October 15, 2010 9:44:44 AM



Page 1

Item ID: D3827-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly (Inboard)

Start Date: 10/15/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 10/21/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 10/10/10

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3827

Rev A

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- cut D3827-1 rib as per dwg D3827

2- drill holes using DT9435 jig and open to finish size as per dwg D3827

3- c'sink as per dwg

4- remove identification markings

5- deburr

6- weld bushing in rib as per dwg D3827

A/R S.S. Rod Batch: 111585

7- grind weld flush

8- deburr if necessary

SAD 10-10-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 2

Item ID: D3827-041

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Stop



Item Name: Rib Assembly (Inboard)

Start Date: 10/15/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 10/21/2010 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC10- Inspect visual per QSI004- ground welds  Memo	0.00  0.00				6			10/10/22
140  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00				6			10/10/22
150  Packaging Packaging	Identify as per dwg & Stock Location: _____ Beutzel call Memo	0.00  0.00							10/10/22 (62)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**Work Order ID 62993**

Friday, October 15, 2010 9:44:44 AM

Page 3

Item ID: D3827-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Rib Assembly (Inboard)

Start Date: 10/15/2010 Start Qty: 6.00

Cust Item ID:

Required Date: 10/21/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/25 *[Signature]*  
MF  
10-10-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Friday, October 15, 2010 9:44:48 AM

Page 1

Work Order ID: 62993

Parent Item: D3827-041

Parent Item Name: Rib Assembly (Inboard)

Start Date: 10/15/2010

Required Date: 10/21/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3759-1 Bushing		Manufactured	No			100	Each	72.0000	3	18			
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Location Loc Qty Loc Code

ST084	21	
56942	21	
WA	51	
54072	9	
61379	42	

M304TS0.750W.065 304 SQ Tube .75x.75x.065W		Purchased	No			100	f	678.6362	8	50.52632			
---	--	-----------	----	--	--	-----	---	----------	---	----------	--	--	--

Location Loc Qty Loc Code

MAT	662.0818	
112398	0	
114482	0.0002	
115494	82.0816	
115593	580	
WA	16.554385	
114520	0.527385	
115274	16.027	

*Pl 10-10-20*

*SAD 10-10-20*

*50.5264*

W/O:		WORK ORDER CHANGES					
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

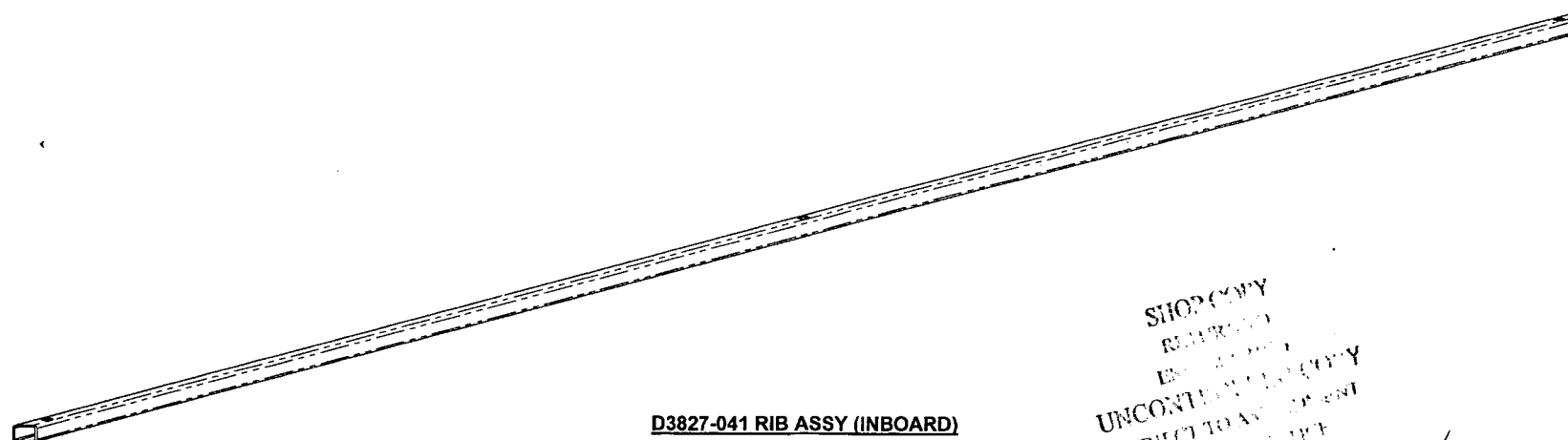
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



8 7 6 5 4 3 2 1

ITEM	QTY	P/N	DESCRIPTION
1	X	D3827-041	RIB ASSY (INBOARD)
2	3	D3759-1	BUSHING
3	1	D3827-1	RIB



**D3827-041 RIB ASSY (INBOARD)**

SHOP COPY  
REMOVED  
UNCONTAINED COPY  
SUBJECT TO ANY  
WITHIN THE  
W. A. C. R.  
NO. 62993  
P80-10-15

**RELEASED**  
08/11/18/14

- NOTES:**
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 4.59 lbs

A	NEW ISSUE	MB	08.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED	ASS		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.23		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3827  
TITLE RIB ASSY (INBOARD)  
REV. A  
SHEET 1 OF 3  
SCALE NTS

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8 7 6 5 4 3 2 1

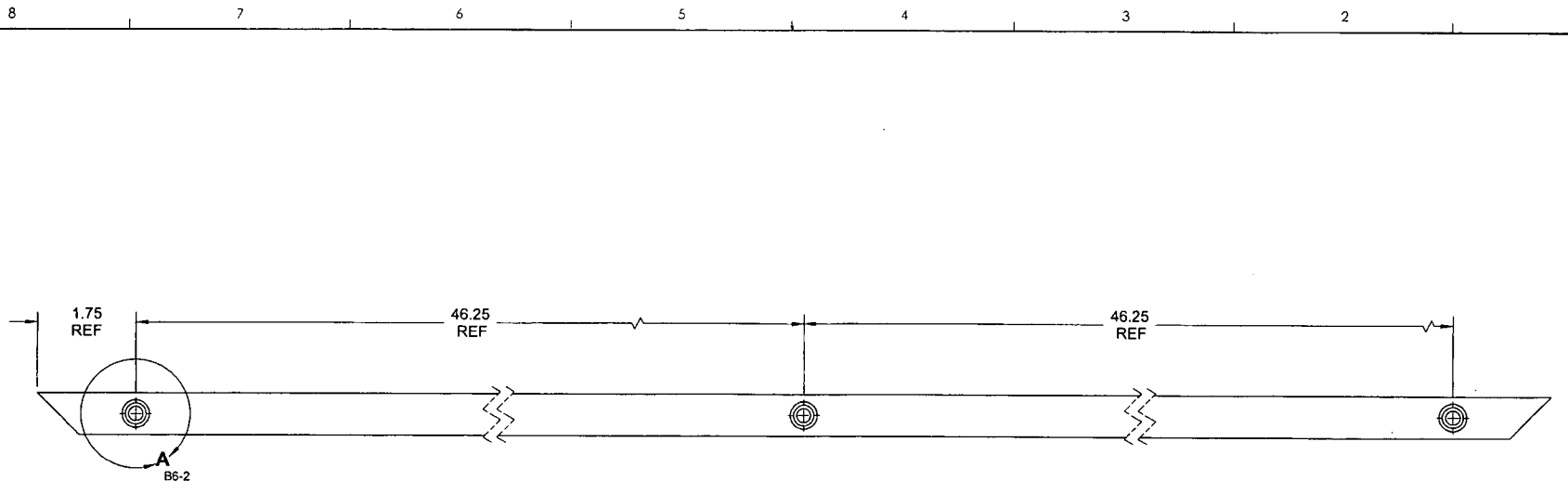
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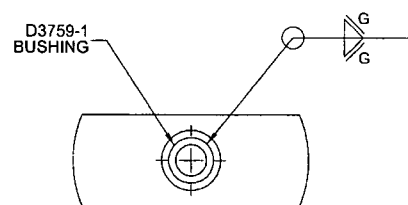
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**NOTE:** Date & initial all entries



**D3827-041 RIB ASSY (INBOARD)**



**DETAIL A** C7-2  
SCALE 2X  
3 PL

*who 62993*

**RELEASED**  
*08/11/18 N4*

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JS</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>JS</i>	<b>D3827</b>	SHEET 2 OF 3
APPROVED	<i>JS</i>	TITLE	SCALE
DE APPR.	<i>JS</i>	<b>RIB ASSY (INBOARD)</b>	NTS
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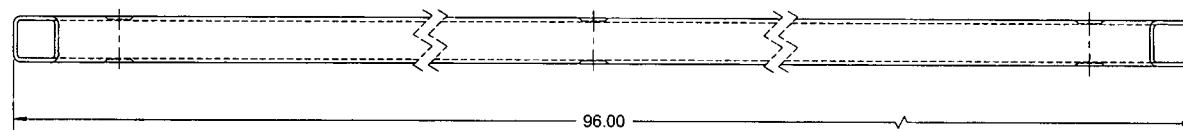
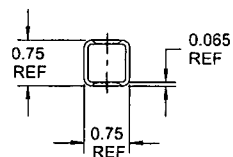
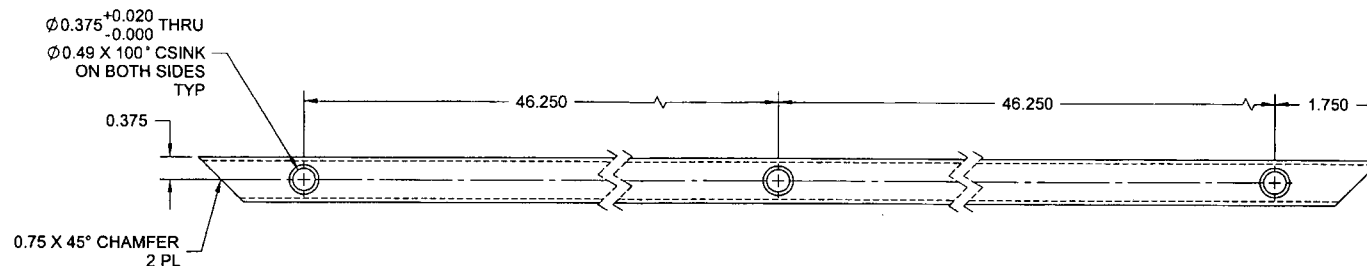
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**D3827-1 RIB**

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
REF. DART SPEC. M304TS0.750W0.065
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 4.55 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3827	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (INBOARD)	NTS
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08/11/2023

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